



# Lightweight Body Filler

05800 • 05801 • 05804

Technical Data Sheet

November 2017

3M Part No.(s)	3M Part Descriptor(s)
05800	3M™ Lightweight Body Filler - One quart - 25.6 fl oz, 757ml
05801	3M™ Lightweight Body Filler - One gallon - 102 fl oz, 3.0L, 0.80 US gal.
05804	3M™ Lightweight Body Filler - Five gallon air dispensed - 3.75 gallons, 14.2L

**Product Description** 3M™ Light weight body filler is a two component material that is vacuum processed to create a smooth texture. 3M™ Lightweight body filler cures tack free in 20 minutes with good sanding and handling characteristics.

- Features**
- Easy spreading & mixing
  - Tack free resin
  - Vacuum processed

**Typical Physical Properties**

**Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

	Part A - Filler	Part B - Cream Hardener
<b>Container</b>	PN 05800 - One quart metal can PN 05801 - One gallon metal can PN 05804 - Five gallon metal can (Air Pail)	1.0 oz. plastic tube 2.75 oz. plastic tube
<b>Base</b>	Polyester resin with styrene monomer	Benzoyl Peroxide
<b>Density</b>	9.2 lb/gal	10.0 lb/gal
<b>Color</b>	Gray	Blue
<b>Flash Point</b>	89°F / 32°C	N/A
<b>Viscosity @ 77°F (25°C) - Brookfield Viscometer</b>	192,000 - 244,000 cps	70,000 - 150,000 cps

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## Product Uses

**For professional use only. Not intended for retail sale.**

Two component polyester compound used to fill dents, dings, gouges and other cosmetic imperfections on bare steel, aluminum, and fiberglass reinforced polyester (FRP). May also be used on many industrial and architectural surfaces needing minor repairs.

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## Typical Performance Properties

**The following times have been determined with ambient air temperature and substrate temperature @ 77°F (25°C) and are considered typical values.**

### SHAPE SAND TIME:

8 to 12 minutes when mixed with 2% hardener by weight @ 77°F (25°C)

### FINISH SAND TIME:

20 minutes when mixed with 2% hardener by weight @ 77°F (25°C)

### RECOMMENDED APPLICATION TEMPERATURE:

Above 45°F (7°C)

### SERVICE TEMPERATURE:

Min. -20°F (-29°C) Max. 180°F (82°C)

### MINIMUM HARDENER:

1.5%

### MAXIMUM HARDENER:

2.75%

**Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

<b>Lap Shear, Steel to Steel:</b>	1,430 psi	ASTM D1002
<b>Lap Shear, Aluminum to Aluminum:</b>	1,320 psi	ASTM D1002
<b>Tensile Strength:</b>	1,600 psi	ASTM D638
<b>Shore D hardness @ 24 hrs:</b>	70	ASTM D2240
<b>Flexural Strength:</b>	2,260 psi	ASTM D790 Procedure A
<b>Shrinkage:</b>	0.72%	LTM 855.0084

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## Directions for Use

1. Wash surface with soap and water to remove water soluble contaminants. Follow the soap and water wash with an appropriate VOC compliant product for removal of surface contaminants.

Sand the surface as needed with grade P40 to P80 3M™ abrasive.

**Note:** If grinding is required use a grade 50 3M™ grinding disc, blow off the sanding dust with clean dry air. When repairing galvanized steel, e-coat, primed/painted surfaces or aluminum, sand with grade P80 3M™ abrasive to remove the paint/primer. Blow off with clean dry compressed air and re-clean the surface using a clean paper or cloth towel and a wax & grease remover/surface cleaner.

2. Apply the required amount of body filler to a clean mixing surface. (Do not use discarded cardboard as a mixing surface as contamination may occur.) The correct hardener to filler ratio = 3 inch diameter circle 1/2 inch thick of filler to a 3 inch strip of cream hardener.
3. Mix the body filler and cream hardener thoroughly, to a uniform color. Gel time/setting time is approximately 3-5 minutes @ 75°F (24°C) using 2% hardener as prescribed. Spread the filler on the mixing board, being sure to break any air bubbles that were introduced during mixing.
4. Apply a thin layer using firm pressure to ensure maximum adhesion being sure to “wet out” the surface completely. Apply additional filler in layers, building up the damaged area higher than the surrounding surface. Maximum filler thickness should not exceed 1/4 inch. Allow curing time of 20 minutes.
5. Sand the filler to the proper contour with 3M™ abrasives, using the following recommended grade sequence: P40, P80, P180. **Note:** If more filler is needed blow off with clean dry compressed air and follow steps 2 through 6.
6. Wait approximately 45 minutes before applying primer and paint, always follow your paint company’s recommended procedures.

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## Applications

Repair of cosmetic surface imperfections in properly prepared auto body, industrial, and architectural substrates.

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## Storage and Handling

### HANDLING

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Keep out of the reach of children. Keep container closed when not in use. Avoid breathing of dust created by cutting, sanding, grinding or machining. For industrial or professional use only. Avoid eye contact with dust or airborne particles.

### STORAGE

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 16 months from the date of manufacture. Store in a dry area at 65-80°F (18-27°C) for optimal shelf life.

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## Precautionary Information

Before using this product, please reference Product Label and/or Safety Data Sheet for Health and Safety Information. Note: Laws controlling the acceptable amounts of Volatile Organic Compounds (VOC's) vary by state, and in some cases by locality. For surface preparation and clean-up activities, consult federal, state and local regulations regarding use of products containing VOCs in your area

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## Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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## Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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